

Work Order ID 124373

124373

Page 1

Item ID: D4895-043

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Item Name: Aft Outboard Beam Assembly

Stop ***NS2***

Start Date: 9/10/14 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 9/10/14 Req'd Qty: 1.00 ***1***

Customer:

Reference:

Approvals: Process Plan: MLS Date: 14-09-17

Tooling:

Date:

Run Start ***NR1***

QC: 1 Date: SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D4895	B

100 0.00

100

Waterjet

Memo 0.00

FLOW CNC Waterjet

CUT BLANK AS PER FILE D4895-3_BLANK

DAS
23
9-89 14-10-17

110 0.00

110

HAAS 1

Memo 0.00

HAAS CNC vertical machine #1

MILL AS PER FOLIO FB194 AND DWG D4895

FOLIO REV: AA

DWG REV: B

DEBURR

DAS
20
9-89 14-12-13

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td style="width: 33%;"> Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ </td> <td style="width: 33%;"> Crosstube ☐ Small Fab ☐ Finishing ☐ Composite ☐ </td> <td style="width: 33%;"> Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ </td> <td style="width: 33%;"> Engineering ☐ Quality ☐ Other ☐ </td> </tr> </table>	Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐	Crosstube ☐ Small Fab ☐ Finishing ☐ Composite ☐	Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐	Engineering ☐ Quality ☐ Other ☐
Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐	Crosstube ☐ Small Fab ☐ Finishing ☐ Composite ☐	Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐	Engineering ☐ Quality ☐ Other ☐			

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other _____ _____ _____
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124373

Page 2

N900040100

Setup Start *NS1*

Stop *NS2*

Start Date: 9/10/14 **Start Qty:** 1.00 ***1***

Required Date: 9/10/14 **Req'd Qty:** 1.00 ***1***

Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

[illegible]

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Crosstube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐
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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
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Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Work Order ID 124373

September-11-14 12:03:47 PM

124373

Page 3

Item ID: D4895-043 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Aft Outboard Beam Assembly
 Start Date: 9/10/14 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 9/10/14 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	QC8- Inspect parts - second check	0.00							
150									DAS
QC	Memo	0.00							08
Quality Control									9-89
160	Chemical Conversion Coat per QSI005 4.1	0.00							
160									
HandFinish	Memo	0.00							
Hand Finishing									
170	QC7-Inspect Chemical Conversion Coat	0.00							
170									DAS
QC	Memo	0.00							38
Quality Control									9-89

12.2 14/12/19

1 14-12-19

DBL

1

DEC 19 2014

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Crosstube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐
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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre.									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Work Order ID 124373

September-11-14 12:03:47 PM

124373

Page 4

Item ID: D4895-043 Accept ***N9000040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Aft Outboard Beam Assembly
 Start Date: 9/10/14 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 9/10/14 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
171	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum	0.00							
171	<i>m 124808</i>					<i>1</i>	<i>0</i>	<i>14-12-22</i>	<i>0308</i>
Powdercoat	Memo	0.00							
Powder Coating	MASK AS PER NOTE 8								
	START TIME: <i>335</i>								
	OVEN TEMPERATURE: <i>320</i>								
	FINISH TIME: <i>11:05</i>								
172	QC3- Inspect Part Finish	0.00							
172									
QC	Memo	0.00							
Quality Control									
						<i>1</i>	<i>0</i>	<i>14-12-23</i>	<i>DAS 9-89</i>
180		0.00							
180									
Small Fab	Memo	0.00							
Small Fab	INSTALL NUTPLATE AS PER DWG								
						<i>1X</i>		<i>15/01/08</i>	<i>DAS 36 9-89</i>

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Crosstube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐
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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
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Training									
Transport									
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Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Work Order ID 124373

124373

Page 5

September-11-14 12:03:47 PM

Item ID: D4895-043 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Aft Outboard Beam Assembly
 Start Date: 9/10/14 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 9/10/14 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190 *190* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00				<u>1</u>			LAS 38 9-89 JAN 08 2015
200 *200* Packaging Packaging	Identify as per dwg & Stock Location: <u>St 444</u> Memo	0.00 0.00				<u>1</u>			<u>CR 15-01-08</u>
210 *210* QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00				<u>MCJ</u>		<u>15-01-08</u>	

Handwritten signature/initials

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td style="width: 33%;"> Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ </td> <td style="width: 33%;"> Crosstube ☐ Small Fab ☐ Finishing ☐ Composite ☐ </td> <td style="width: 33%;"> Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ </td> <td style="width: 33%;"> Engineering ☐ Quality ☐ Other ☐ </td> </tr> </table>	Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐	Crosstube ☐ Small Fab ☐ Finishing ☐ Composite ☐	Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐	Engineering ☐ Quality ☐ Other ☐
Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐	Crosstube ☐ Small Fab ☐ Finishing ☐ Composite ☐	Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐	Engineering ☐ Quality ☐ Other ☐			

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Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Picklist Print

September-11-14 12:03:46 PM

Page 1

Work Order ID: 124373

124373

Parent Item: D4895-043

D4895-043

Parent Item Name: Aft Outboard Beam Assembly

Start Date: 9/10/14

Required Date: 9/10/14

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP REV:A NEW ISSUE 13-05-27 JLM VERIFIED BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

M6061T6B1.000X12.00
0

Purchased

No

f

54.5000

3.157895

M6061T6B1 000X12 000

6061-T6 Bar 1.00 x 12.00

**

2.5

DAS
23
9-89

14-10-17

Location

Loc Qty

Loc Code

MAT005

54.5

123649

2

m129639

16.5

m130013

36

130013

MS20426AD3-5

Purchased

No

Each

6,604.000

4

MS20426AD3-5

Rivet

**

15/01/08

DAS
36
9-89

Location

Loc Qty

Loc Code

ST314

6604

4444

1806

4533

4798

4

MS21059L4

Purchased

No

Each

92.0000

2

MS21059L 4

Nutplate

**

15/01/08

DAS
36
9-89

Location

Loc Qty

Loc Code

GA

92

m129764

92

2

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐															
Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐															
Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐															
Large Fab ☐	Composite ☐	Supplier ☐																

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Material									
Operator									
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Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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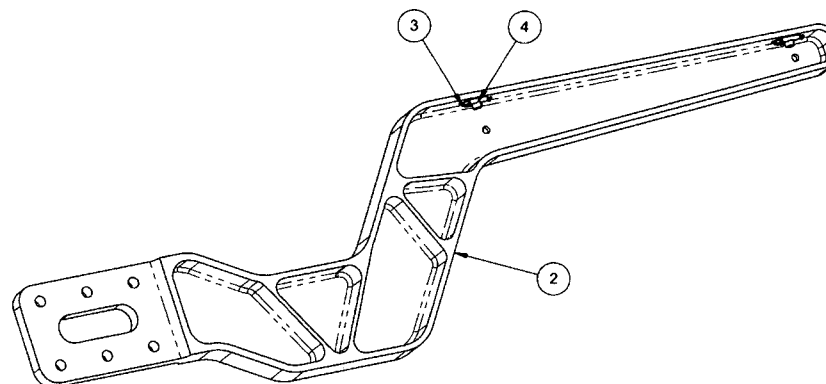
DART AEROSPACE LTD		Work Order: 124373
Description: Aft Outboard Beam		Part Number: D4895-3
Inspection Dwg: D4895	Rev: <i>AB 9.1</i>	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

	Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
CNC Mil	R0.13	+/-0.030	.125	✓		Rad gauge	
	0.150	+/-0.010	.153	✓		SLO2	Mic
	1.00	+/-0.030	.986	✓		SLO8	Vern
	6.97	+/-0.030	6.970	✓		Height gauge	
	Ø0.257	+0.006/-0.001	.257	✓		gauge Pin	
	0.80	+/-0.030	.794	✓		SLO8	
	3.00	+/-0.030	3.000	✓		"	
	0.150	+/-0.010	.149	✓		"	
	0.250	+/-0.010	.249	✓		"	
	5.75	+/-0.030	5.750	✓		"	
	R0.38	+/-0.030	.380	✓		Rad gauge	
	R1.50	+/-0.030	1.500	✓		Rad gauge	
	32.55	+/-0.030	32.550	✓		SLO1	Tape
	0.200	+/-0.010	.200	✓		SLO8	
	12.000	+/-0.005	12.000	✓		SLO1	
	1.25	+/-0.030	1.248	✓		SLO8	
	3.50	+/-0.030	3.500	✓		"	
	3.600	+/-0.005	3.600	✓		"	
	0.60	+/-0.030	.598	✓		"	
	0.80	+/-0.030	.798	✓		"	
	2.300	+/-0.005	2.300	✓		"	
	3.00	+/-0.030	3.000	✓		"	
	Ø0.377	+0.006/-0.001	.378	✓		gauge Pin	
Manual Mil	Ø0.098	+0.004/-0.001	.099	✓		SLO8	
	Ø0.179 X 100°	+/-0.010 x 0.5°	.177 x 100°	✓			
	0.60	+/-0.030	.600	✓			
	1.55	+/-0.030	1.545	✓			
	12.000	+/-0.005	12.000	✓			
	Ø0.260	+0.006/-0.001	.261	✓			
	0.500	+/-0.005	.500	✓			
	R0.25	+/-0.030	.250	✓			
	0.500	+/-0.010	.501	✓			
	0.25	+/-0.030	.250	✓			
	5.50	+/-0.030	5.500	✓			

Measured by: 20 9-89	Audited by: <i>D.A.</i> DAS 08 9-89	Preliminary Approval: <i>[Signature]</i>
Date: 14-12-13	Date: 14/12/19	Date: <i>[Signature]</i>
Rev A	Date 14.01.21	Change New Issue
	Revised by KJ	Approved <i>[Signature]</i>

ITEM	QTY -041	P/N	DESCRIPTION
1	X	D4895-041	FWD OUTBOARD BEAM ASSY
2	1	D4895-1	FWD OUTBOARD BEAM
3	4	MS20426AD3-(5)	RIVET
4	2	MS21059-4	NUT PLATE



D4895-041 FWD OUTBOARD BEAM ASSY

SHOP COPY
RETURN TO
ENGINEERING
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WITHOUT NOTICE
WORK ORDER
NO. 124373 MLCJ

14-09-13

RELEASED
2014-07-24

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 3.31 lbs

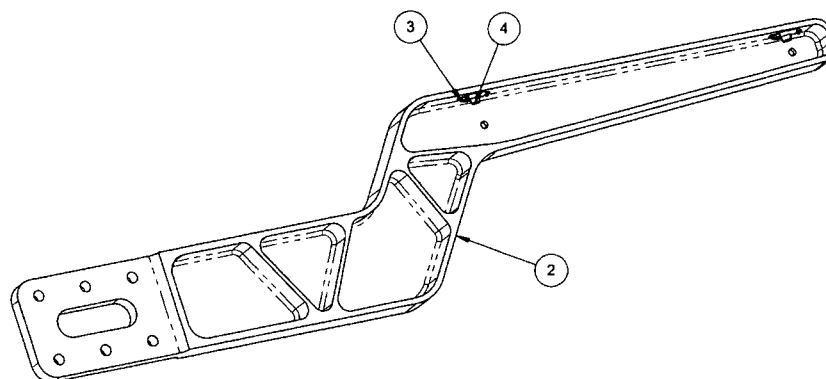
B	ADD D4895-5/-7/-045/-047 (ZN A4-3, A4-4, A4-7, A4-8), ADD NOTE 9 (ZN A8-5, A8-6, A8-7, A8-8)	RF	14.04.11
A	NEW ISSUE	RF	13.05.24
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D4895 TITLE OUTBOARD BEAM SCALE NTS COPYRIGHT © 2013 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	
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CHECKED	VS		
MFG. APPR.	JLM		
APPROVED	HS		
DE APPR.	DS		
DATE	14.04.11		

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REV. B

SHEET 1 OF 9

ITEM	QTY -043	P/N	DESCRIPTION
1	X	D4895-043	AFT OUTBOARD BEAM ASSY
2	1	D4895-3	AFT OUTBOARD BEAM
3	4	MS20426AD3-(5)	RIVET
4	2	MS21059-4	NUT PLATE



D4895-043 AFT OUTBOARD BEAM ASSY

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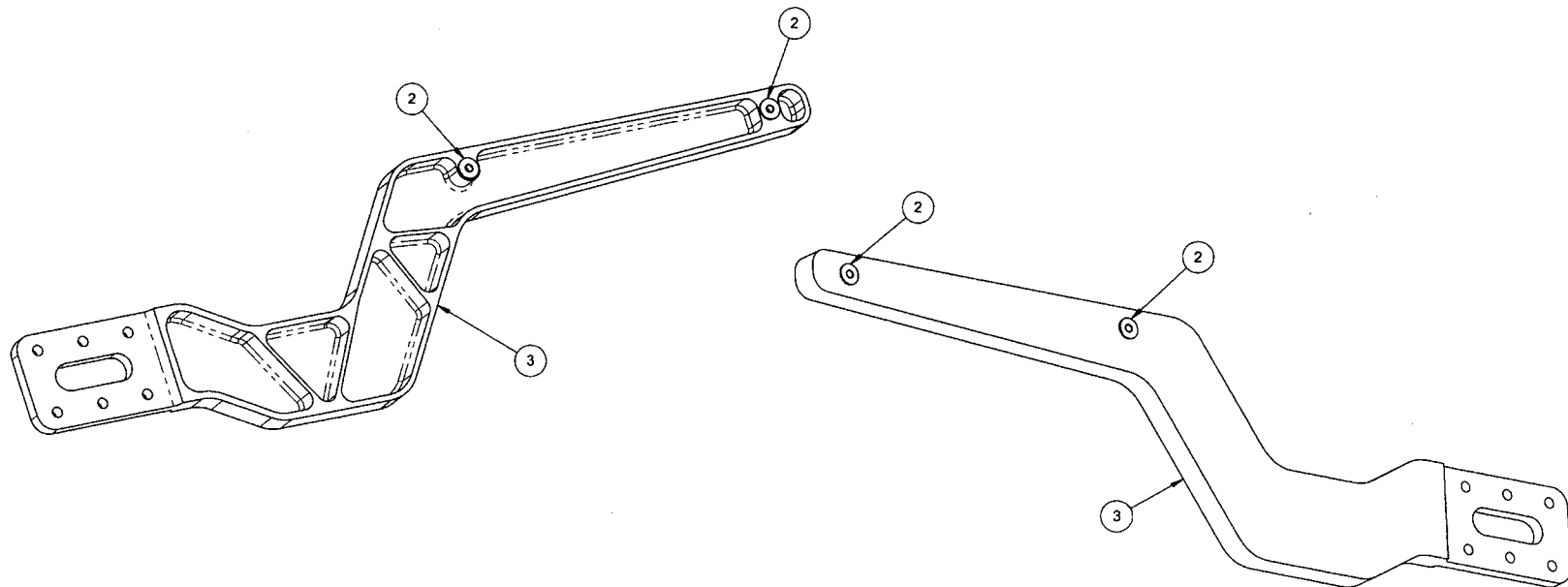
NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 3.25 lbs

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MFG. APPR.	JLM	D4895	SHEET 2 OF 9
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DE APPR.	DS	OUTBOARD BEAM	NTS
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ITEM	QTY -045	P/N	DESCRIPTION
1	X	D4895-045	FWD OUTBOARD BEAM ASSY
2	4	D4859-1	BUSHING
3	1	D4895-5	FWD OUTBOARD BEAM



D4895-045 FWD OUTBOARD BEAM ASSY

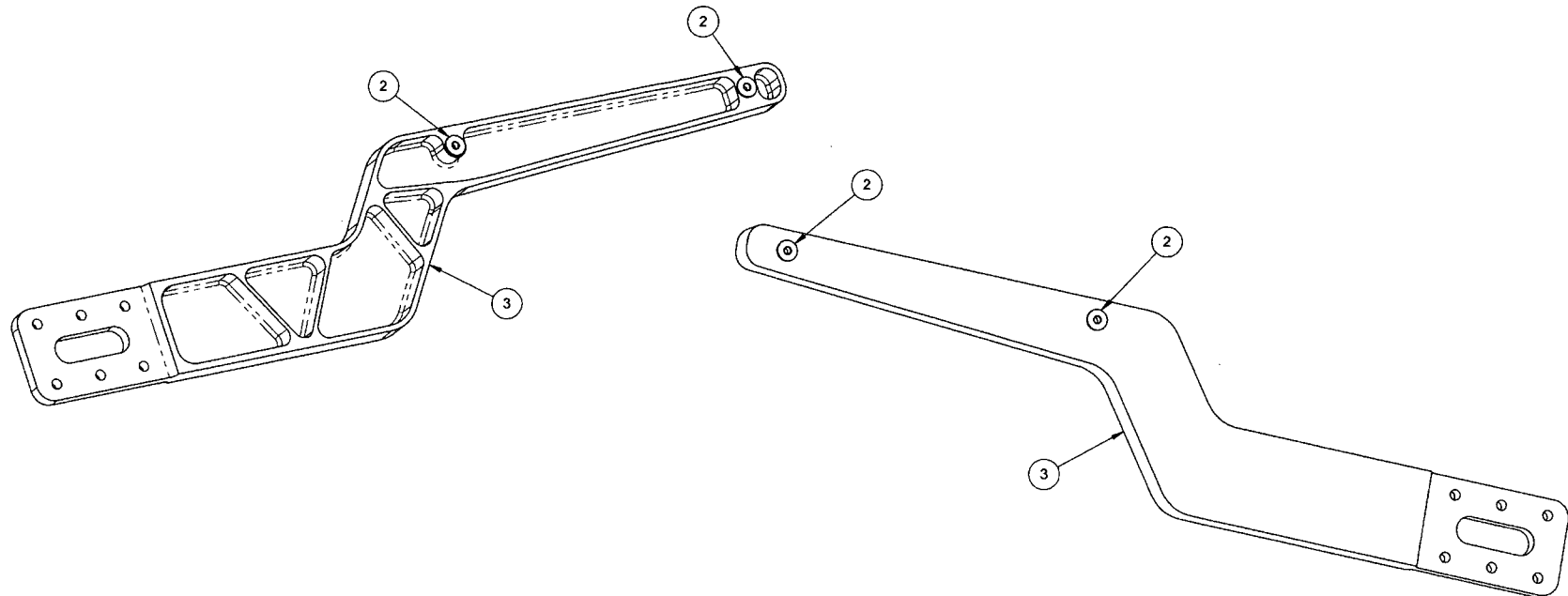
NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 3.50 lbs
- 8) PRESS FIT D4859-1 INTO D4895-5. IT IS ACCEPTABLE USE MAGNABOND ADHESIVE, REMOVE EXCESS ADHESIVE FROM BUSHING HOLE

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	MFG. APPR.	JLM	TITLE OUTBOARD BEAM	SHEET 3 OF 9
	APPROVED	HS		SCALE
	DE APPR.	DS		NTS
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ITEM	QTY -047	P/N	DESCRIPTION
1	X	D4895-047	AFT OUTBOARD BEAM ASSY
2	4	D4859-1	BUSHING
3	1	D4895-7	AFT OUTBOARD BEAM



D4895-047 AFT OUTBOARD BEAM ASSY 

NOTES:

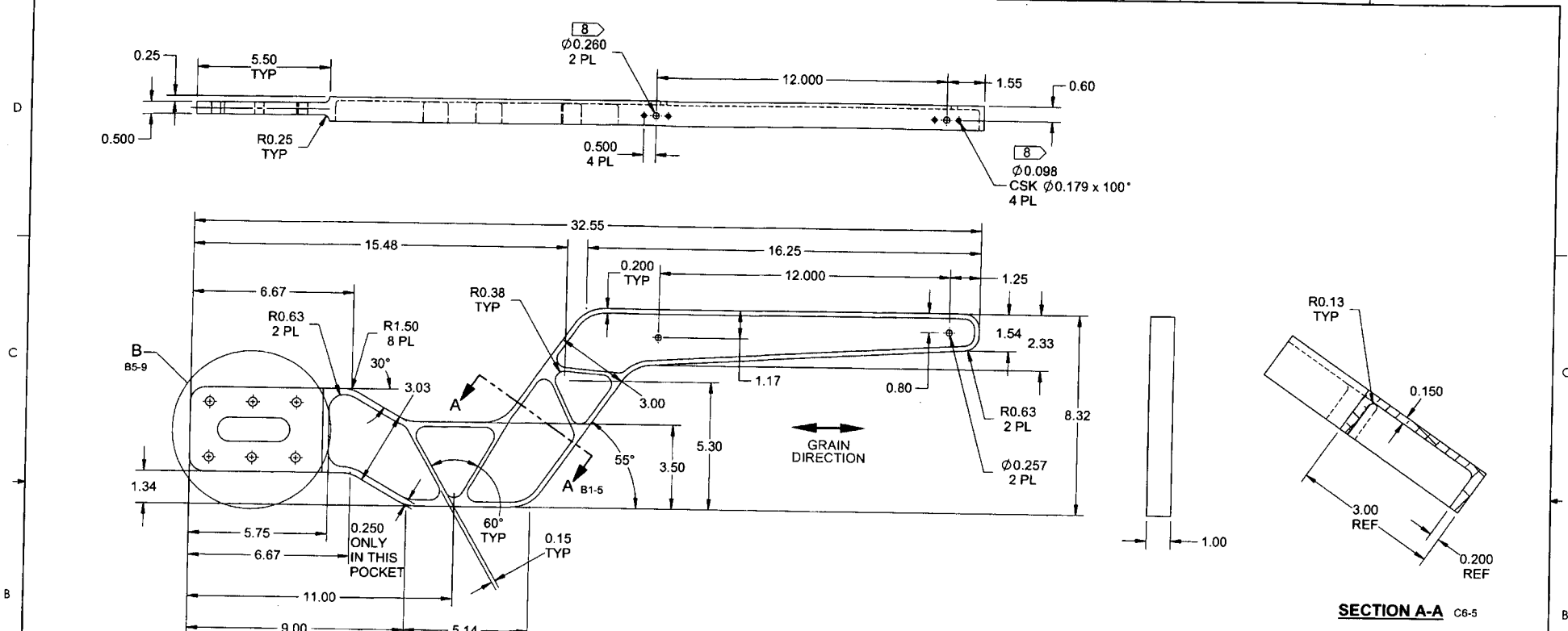
- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 3.44 lbs
- 8) PRESS FIT D4859-1 INTO D4895-7. IT IS ACCEPTABLE USE MAGNABOND ADHESIVE, REMOVE EXCESS ADHESIVE FROM BUSHING HOLE

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MFG. APPR.	JLM		SHEET 4 OF 9
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	OUTBOARD BEAM	NTS
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8 7 6 5 4 3 2 1



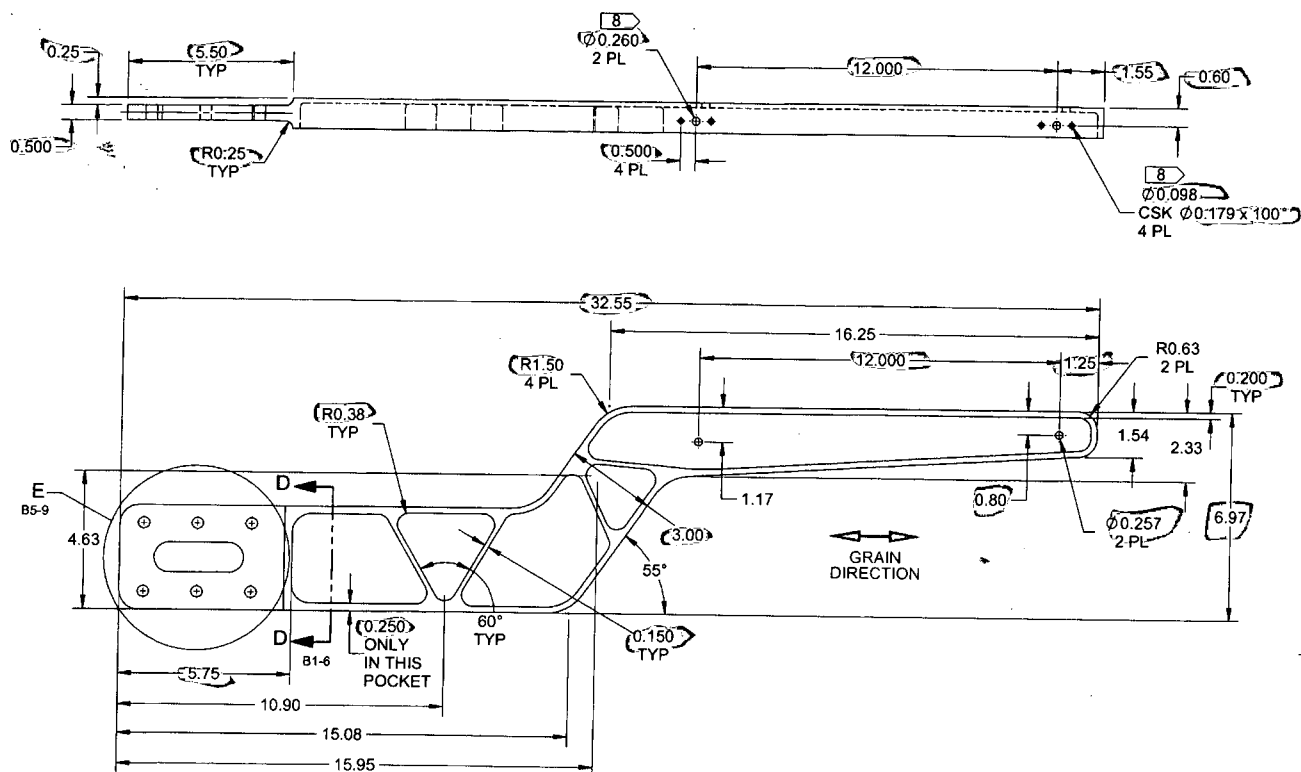
D4895-1 FWD OUTBOARD BEAM

- NOTES:**
- 1) MATERIAL: 6061-T6/T651/T6510/T6511/T62 ALUMINUM BAR
PER QQ-A-225/8 OR AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)
OR QQ-A-200/8 OR AMS-QQ-A-200/8 (OR AMS 4160)
OR ASTM B211 OR ASTM B221
REF DART SPEC M6061T6B
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 3.30 lbs
 - 8) MASK HOLES PRIOR TO POWDER COAT
 - 9) UNDEFINED FEATURES CONTROLLED BY CAD FILE D4895-1.SLDPRT

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	MFG. APPR.	JLM	SHEET 5 OF 9	
	APPROVED	HS	TITLE	SCALE
	DE APPR.	DS	OUTBOARD BEAM	NTS
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8 7 6 5 4 3 2 1



D4895-3 AFT OUTBOARD BEAM

NOTES:

- 1) MATERIAL: 6061-T6/T651/T6510/T6511/T62 ALUMINUM BAR
PER QQ-A-225/8 OR AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)
OR QQ-A-200/8 OR AMS-QQ-A-200/8 (OR AMS 4160)
OR ASTM B211 OR ASTM B221
REF DART SPEC M6061T6B
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 3.25 lbs
- 8) MASK HOLES PRIOR TO POWDER COAT
- 9) UNDEFINED FEATURES CONTROLLED BY CAD FILE D4895-3.SLDPRT

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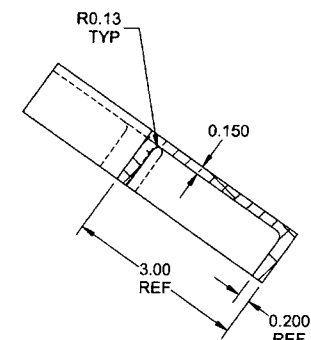
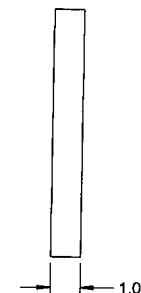
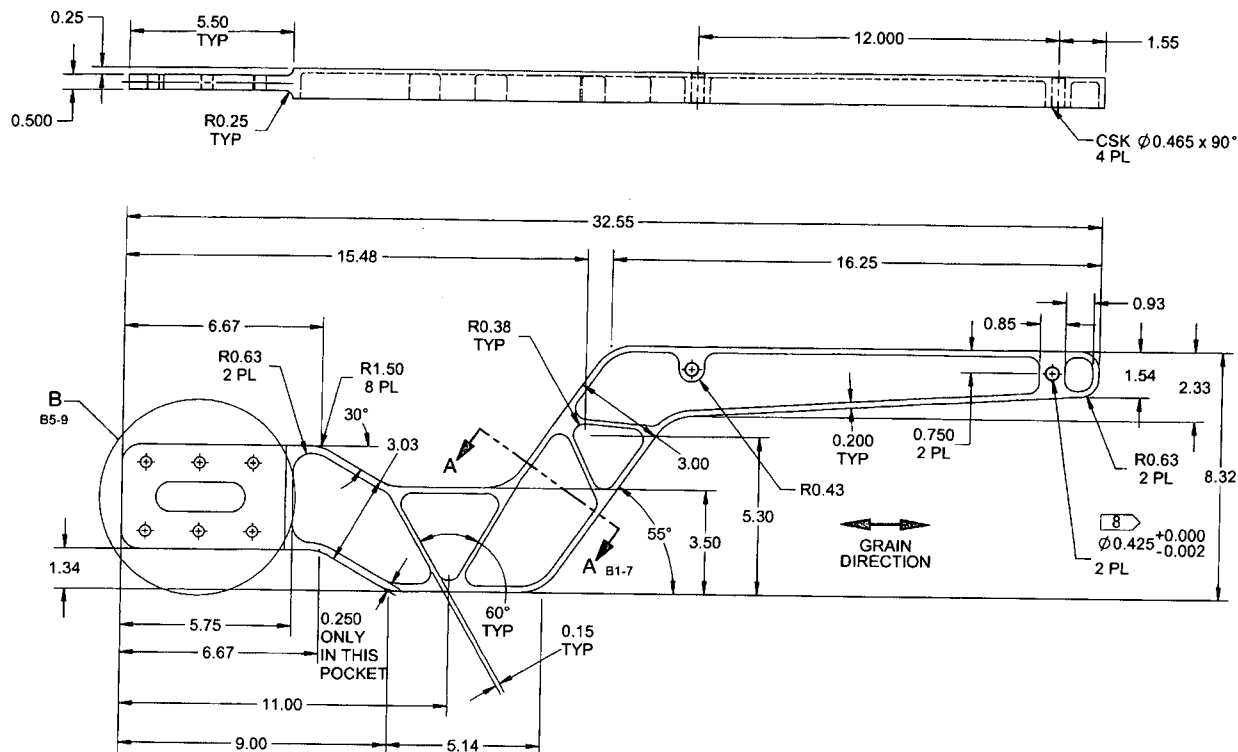
DESIGN	RF
DRAWN	RF
CHECKED	VS
MFG. APPR.	JLM
APPROVED	HS
DE APPR.	D9
DATE	14.04.11

DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWING NO. D4895	REV. B
TITLE OUTBOARD BEAM	SHEET 6 OF 9
SCALE NTS	
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SECTION D-D B7-6

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SECTION A-A C6-7

D4895-5 FWD OUTBOARD BEAM

NOTES:

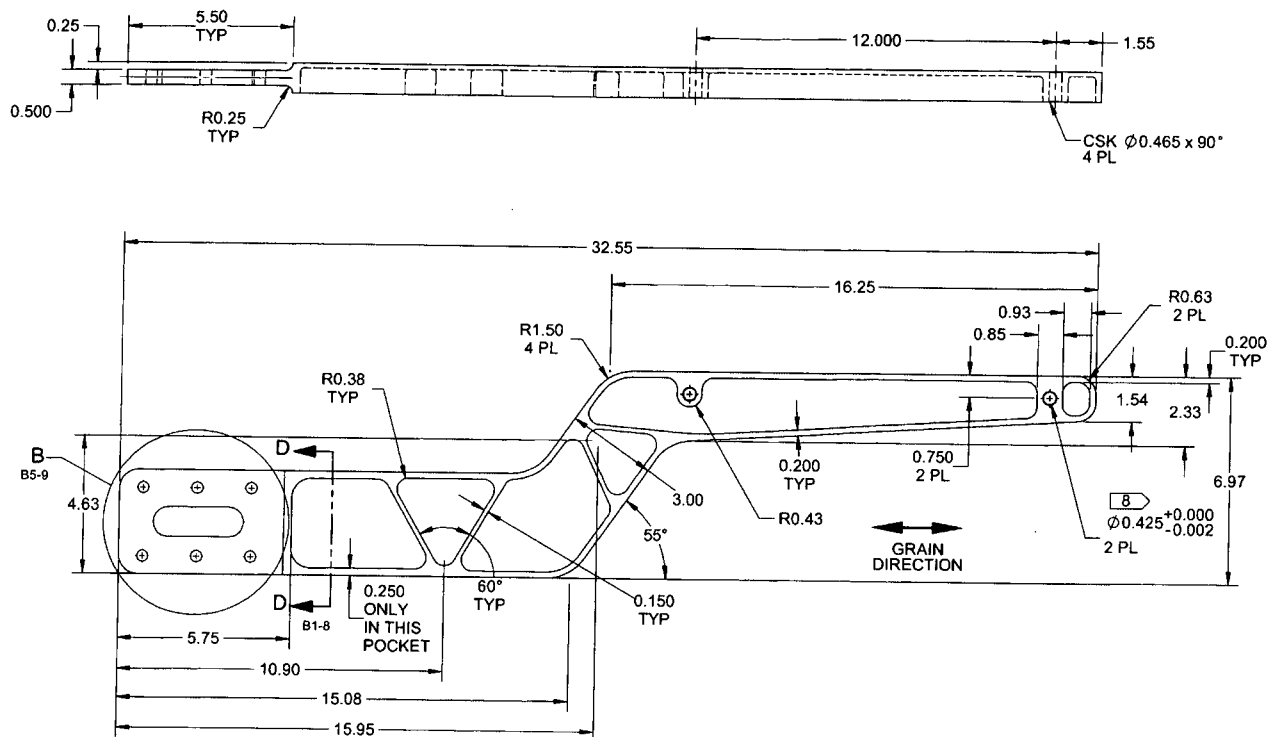
- 1) MATERIAL: 6061-T6/T651/T6510/T6511/T62 ALUMINUM BAR
PER QQ-A-225/8 OR AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)
OR QQ-A-200/8 OR AMS-QQ-A-200/8 (OR AMS 4160)
OR ASTM B211 OR ASTM B221
REF DART SPEC M6061T6B
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 3.44 lbs
- 8) MASK HOLES PRIOR TO POWDER COAT
- 9) UNDEFINED FEATURES CONTROLLED BY CAD FILE D4895-5.SLDPRT

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MFG. APPR.	JLM	D4895	SHEET 7 OF 9
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	OUTBOARD BEAM	NTS
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8 7 6 5 4 3 2 1



D4895-7 AFT OUTBOARD BEAM

NOTES:

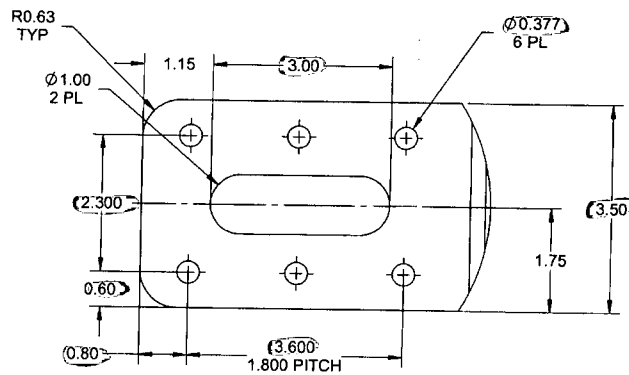
- 1) MATERIAL: 6061-T6/T651/T6510/T6511/T62 ALUMINUM BAR
PER QQ-A-225/8 OR AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)
OR QQ-A-200/8 OR AMS-QQ-A-200/8 (OR AMS 4160)
OR ASTM B211 OR ASTM B221
REF DART SPEC M6061T6B
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 3.39 lbs
- 8) MASK HOLES PRIOR TO POWDER COAT
- 9) UNDEFINED FEATURES CONTROLLED BY CAD FILE D4895-7.SLDPRT

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MFG. APPR.	JLM	TITLE OUTBOARD BEAM	SHEET 8 OF 9
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DE APPR.	DS		
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DETAIL B
C8-5
C8-6
C8-7
C8-8

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MFG. APPR.	JLM	SHEET 9 OF 9	
APPROVED	HS	TITLE	SCALE
DE APPR.	D3	OUTBOARD BEAM	NTS
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